

CSP-COM-5  
TEMP. REV. 94-001MDHS  
COMPONENT OVERHAUL MANUAL

UNDER REVIEW

URF 19-1213 19.11.07 (VM)

SHOP COPY

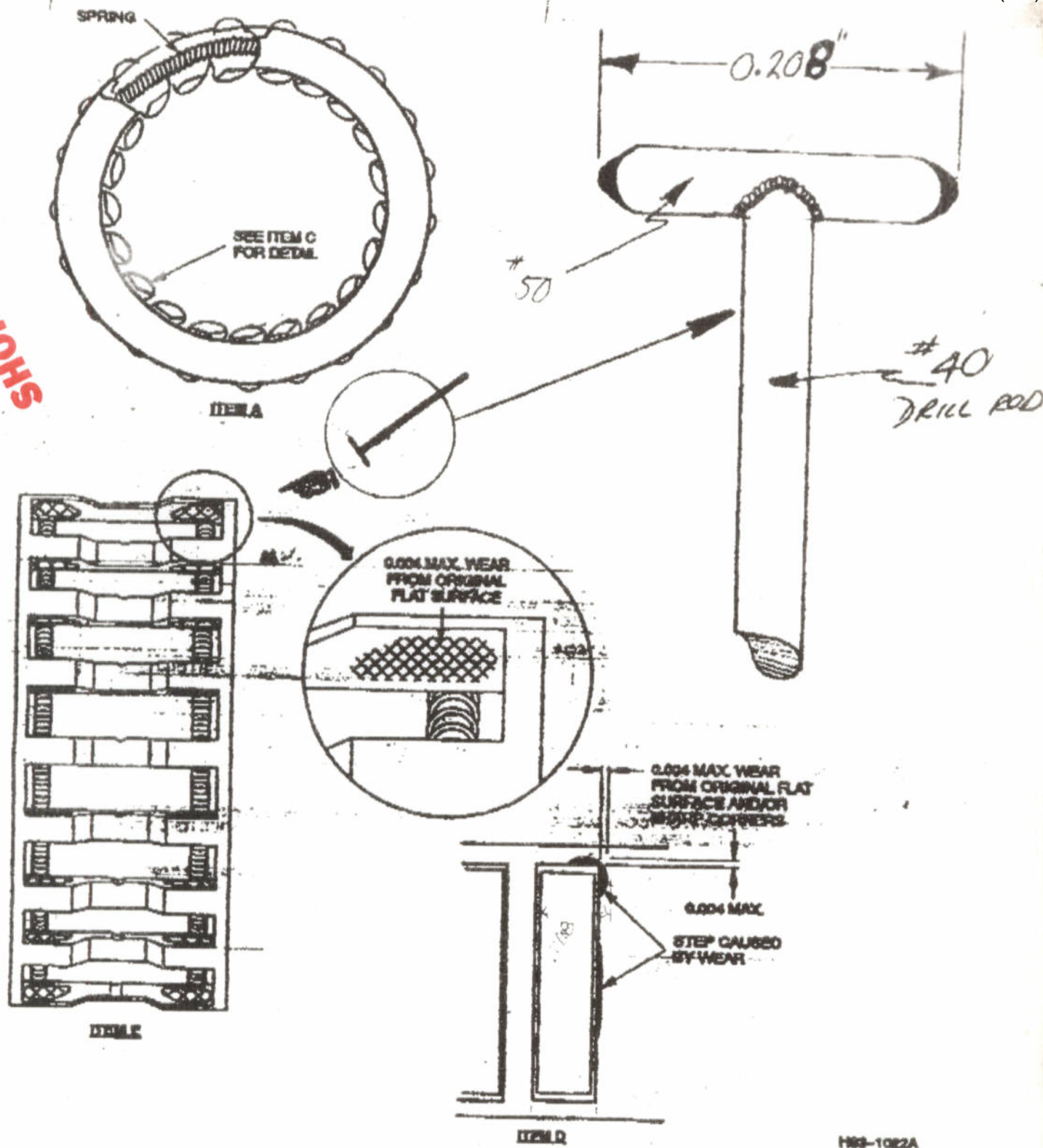


Figure 505. Inspection Requirements of 389D25851 Sprag Assembly

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May 25, 1994

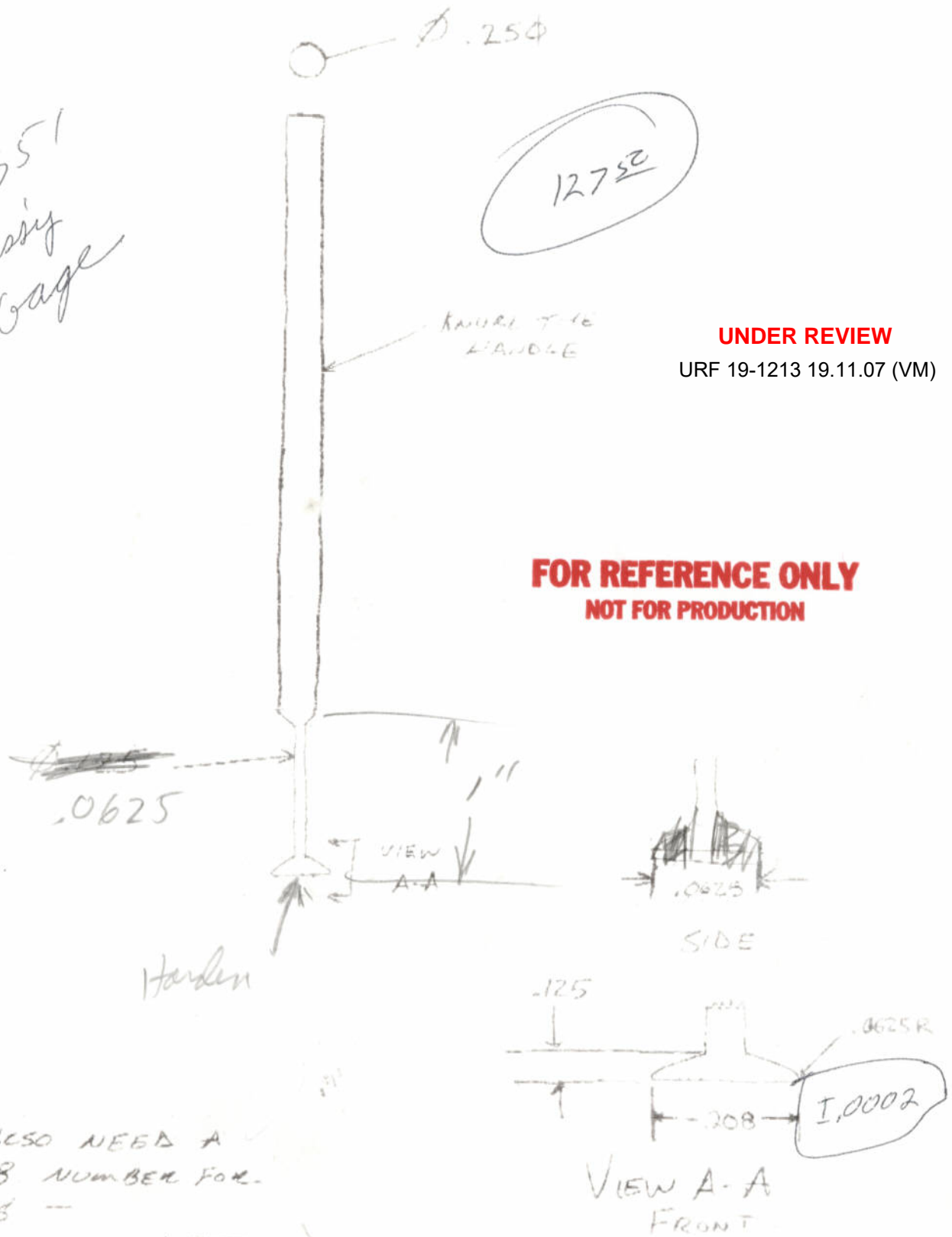
63-10-10

EFFECTIVITY: ALL

USE YOUR TOOL BETTER -

HERE ARE THE SPECIFICS I'M REQUESTING

RB 25351  
Sprag Assy  
No-60 Gage



UNDER REVIEW

URF 19-1213 19.11.07 (VM)

FOR REFERENCE ONLY  
NOT FOR PRODUCTION

P.S - I ALSO NEED A  
R.B. NUMBER FOR  
THIS -

*Mike,  
I can have this  
made in AAC but will  
need a CCN —  
Dave Myers*

**E.M. HELI-LOGISTICS LTD.**  
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### FAX Transmission

TO	MCDONNELL DOUGLAS	DATE	July 5, 1995
ATTN	XAVIER	FAX	602-891-3952
FROM	Dave MacFarlane	PAGES	2

IF ALL PAGES ARE NOT RECEIVED, PLEASE CONTACT US AT 604-533-4464.

XAVIER;

Sorry for the delay in giving you the information regarding how we measure sprag window wear. I have given you a sketch of what the tool looks like, but it might be better if I explain how we measure the wear.

We fabricated the tool out of drill rod material, which was easy to acquire, and made the "handle" out of a 5" long piece of #40 (.098") drill bit shank. For the "T" section, we used another piece of drill bit shank, with a dimension of .070" or a #50 drill, and machined the ends to rounded points with a dimension of .208" which is the maximum allowable wear for the sprag window. This "T" section was silver soldered on to the top of the handle.

We measured the window wear by placing the one point of the tool into one side of the window wear, and then rotated the tool point towards the other side wear step. If we could not rotate the tool fully, we determined the wear step was not beyond limits. We found that due to the wear step, the tool could be turned and angled in such a way that it was possible to place the points in both maximum wear step areas versus rotation of the tool.

While this method does not show the minimum wear, it did provide us with a go-no-go indication.

I hope this information is helpful, and if you require anything more, please let me know.

Best regards,  
D. MacFarlane



**UNDER REVIEW**

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## MCDONNELL DOUGLAS HELICOPTER SYSTEMS

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DATE 15 AUG 95LEAD + 2TO: BOB OR RUBY TIFTDATAFAX NO: (303) 882-4147TELEPHONE NO: (303) 882-4147FROM: DAVE MYERSTELEPHONE NO: (602) 891-4679

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COMMENTS: \_\_\_\_\_

COULD YOU MAKE A PROTO-TYPE TOOL FOR  
ME TO USE?

IF THIS TOOL WORKS WE <sup>WOULD</sup> LIKE YOU  
TO STOCK IT WITH YOUR P/N.

Dave Myers